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Memo

Packaging

Packaging

DQA:		_ Date:										TOACT		
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE		ork Order up	odate only	AEROSPACE		
				,	DISPOSITION			AGA				<u> </u>		
Work Orde	er:									T DEPARTMENT/PROCESS				
					Rework	1	Skid-tube Cross			Water Jet	Engineering			
Part N	ło				Scrap			Machining Small			d. Eng. Coor.	Quality		
					Use-as-is					Rec/Sto	re/Packaging	Other		
NCR N	10				Suspected Unapproved	ted Unapproved Large Fab Composite					Supplier			
Root				Desci	cription of work order update		Initial	Action		Sign &				
Cause	Date	Step	Qty		or non-conformance	Ct	nief Eng	Description		Date	Verification	QC Inspector		
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Operator														
Offset/Setup														
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	Centre N	ot Concei	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		ļ	Over/Under	tolerance	Set-up		
	Cracks			_	Broken/Damage/Defect	<u> </u>	Hardwa		<u> </u>	Part Incorred		Temperature/Cure		
		nk/Ripple	/Wave		Burrs	匚	Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld		
ļ	Cuffs			<u> </u>	Contamination		4	ions Incomplete/Unclear		Part Moved	L	Wrong Stock Pulled		
	Crushing			<u> </u>	Countersink		1	ned/off center		Positioned V		7		
	Heat Treat			\perp	Cut Too Short	L.	Mislabe			Power Loss/:	Surge	Other		
		in Strip in	Tube		Drawing	oxdot	Misread							
[Marks/Cl				Drill Holes	L	Off-set							
ļ	Turning Sequence			_	Finish	L	4	Calibration						
	Wave/Twist in Tube			- 1	Fit/Function	1	Out of 9	Sequence						

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Work Orde Wednesday, July				*104432*									Page 2		
Item ID: Revision ID: Icem Name:	D2966-1-BE	•		Accept	*N900	*N900040100			Setup	Start Stop	171.	S1* S2*			
Start Date: Required Date: Reference:	7/10/2013 7/15/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:							-			
Approvals:					Date:				Run	Start Stop		R1* R2*			
Sequence ID/ Work Center II 310 *210* QC Quality Control	D	Operation Description QC21- Final Inspection Memo	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Qty		Reject Number	Insp. Stamp			

pl13-09-h

DQA:		_ Date:				™DΔRT						
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / U		Nork Order u	pdate only	AEROSPACE
187- al- Oad		_			DISPOSITION				-	DEPARTMENT		
Work Orde	er				Pawark	1	Skid tuba Crosstub			- 7	Water Jet	_ Engineering _
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raiti	···				Use-as-is		Thermoforming Finishir				re/Packaging	Other
NCR N	No.				Suspected Unapproved	l	Large Fab Composi			- 1100/310	Supplier	
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Root			<u> </u>	Desc	ription of work order update		nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
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	Bending				Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced
	Centre N	lot Conce	ntric	L	BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ct [Temperature/Cure
	Crimp/K	ink/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/M	issing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/l	Jnclear [Part Moved		Wrong Stock Pulled
	Crushing	3			Countersink		Misalie	ned/off center		Positioned \	Vrong	
	Heat Tre	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	Inspection	on Strip in	Tube		Drawing		Misread	j	_			
i	Marks/C	hatter			Drill Holes		Off-set					
	Turning	Sequence			Finish		Out of (Calibration				
	Wave/Twist in Tube				Fit/Function		Out of	equence				

Picklist Print

Wednesday, July 10, 2013 2:49:11 PM

Work Order ID: 104432

104432

Parent Item:

D2966-1-BENT

D2966-1-RFNT

Parent Item Name:

Skidtube Assembly 105

Start Date: 7/10/2013

Required Date: 7/15/2013

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP rev A 10.09.17 New issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
D2962-125		Manufactured	No				Each	5.0000		1	$\overline{}$			

D2962-125

Outer Tube Extrusion

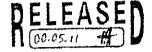
Location Loc Oty Loc Code HALL 5 17532

DQA:			Date:		<u> </u>	WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:					3111 01		w	ork Order up	date only	AEROSPACE		
Work Orde	or.	-				DISPOSITION			AGAI						
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	-	Bending	_			Bend	_	•	Program	 	Outside Dim	} —-	Pressure/Forced		
	\vdash		ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		<u> </u>	Over/Under)	Set-up		
	⊢⊣	Cracks			<u> </u>	Broken/Damage/Defect	匚	Hardwa		<u> </u>	Part Incorred		Temperature/Cure		
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			n Strip in	Tube	<u> </u>	Drawing	<u>_</u>	Misread							
	\vdash	Marks/Ch			<u> </u>	Drill Holes	<u> </u>	Off-set							
	Turning Sequence				-	Finish	<u> </u>	1	Calibration				- 		
l i	ı I	Wave/Twist in Tube				Fit/Function	ı	IOut of 9	Seguence						





	DESIGN PF	DRAWN BY	DART AEROSPACE US	A, INC.
	CHECKED	APPROXED	DRAWING NO.	REV. A
į		**	D2966	SHEET 1 OF 2
	DATE		TITLE	SCALE
	00.03.08		BO 105 SKIDTUBE ASSEMBLY	NTS
	Α	00.03.08	NEW ISSUE	



Qty	Part Number	Description
X	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130	INSERT
	or ALS4-1032-130	
	or AKS7-1032-130	
	or AKS4-1032-130	
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
1	D3176-1	BUSHING
1	D3176-3	Nut

104432 D13-07-10



GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/ -291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS, INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH, SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART **QSI 005 4.4 (OPTIONAL)**

BLACK SAMPTEY (REF 4.3.5.7)

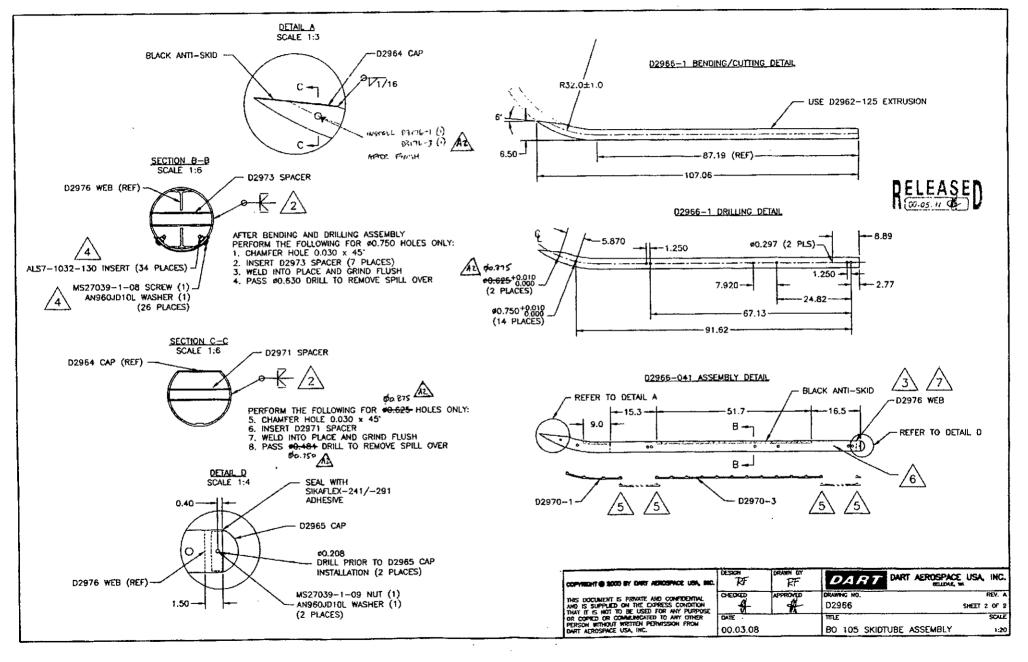
12	02.10.30	ADD 03176-1/-3	A a
ΑI	01.01.24	CHANGE COLOR TO BLACK	SANDTEX TU

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DQA:	·	Date:			•			_					ΔC_{*}	DT
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					Use-as-is		Thermoforming Finishin			-	Rec/\$to	re/Packaging	Oth	er
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	Turning Sequence				Finish		Out of (Calibration						
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H:/FORMS/Quality Assurance\approved QA/NCRWO RevH



DQA:		Date:			- TADT									
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Part N	lo				Scrap			Machining Small Fal	_	Pro	d. Eng. Coor.	Quality		
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